

Work Order ID 138188

Tuesday, October 27, 2015 11:05:27 AM

138188

Page 1

Item ID: 646.9603

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Lower Cutter Assy Low

Stop

NS2

Start Date: 11/17/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/17/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MCS Date: OCT 27 2015

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
646.9600	N/C

110	Pick Kit	0.00
-----	----------	------

110

Packaging

Memo

0.00

Packaging

2x

16/02/24

DAS
36
9-89

120

0.00

120

Small Fab

Memo

0.01

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: M133588
exp. date: 07/17

2x

16/02/24

DAS
36
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

②

DAS
36
9-89

FEB 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

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2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: CC K 036 0.00***140***

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER IAW MPP-120

2 MLJ 16-02-25

150

QC21 - Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

FEB 26 2016

MLJ

FEB 26 2016

MLJ

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, October 27, 2015 11:05:27 AM

Page 1

Work Order ID: 138188

138188

Parent Item: 646.9603

646 9603

Parent Item Name: Lower Cutter Assy Low

Start Date: 11/17/2015

Required Date: 11/17/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701 *646 9701* Cutter Sub Assembly		Manufactured	No			110	Each	4.0000	1	2	DAS 30 9-89		

FEB 24 2016

Location

Loc Qty

Loc Code

cck012

4

B 141900 (2)

127683

1

127684

3

646.9813

Manufactured No

110

Each

3.0000

1

2

646 9813

Lower Deflector Low

**

DAS
30
9-89

FEB 24 2016

Location

Loc Qty

Loc Code

CCK106

3

125263

3

2

MS21042L08

Purchased No

110

Each

454.0000

3

6

MS21042L 08

Nut

**

DAS
30
9-89

FEB 24 2016

Location

Loc Qty

Loc Code

CA

101

m129682

101

GA

204

m133134

204

ST304

149

m128401

102

m128429

3

m131317

26

m132930

18

6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Picklist Print

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Page 2

Work Order ID: 138188

138188

Parent Item: 646.9603

646 9603

Parent Item Name: Lower Cutter Assy Low

Start Date: 11/17/2015

Required Date: 11/17/2015

Start Qty: 2.00

Required Qty: 2.00

MS27039-08-19

Purchased

No

110

Each

486.0000

3

6

MS27039-08-19

Screw

DAS
30
9-89

FEB 24 2016

Location

Loc Qty

Loc Code

ckk007a

100

M134 a3 ①

m133077

100

GA

186

m132930

186

ST273A

171

m131317

171

ST281

29

m131264

29

NAS1149FN832P

Purchased

No

110

Each

2,186.000

6

12

NAS1149FN832P

Washer

DAS
30
9-89

FEB 24 2016

Location

Loc Qty

Loc Code

GA

346

M133769

125268

346

ST260a

500

M133316

500

ST267

419

125268

100

M133284

319

st268

921

M130388

921

Tuesday, October 27, 2015 11:05:27 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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OTHER : ☐											

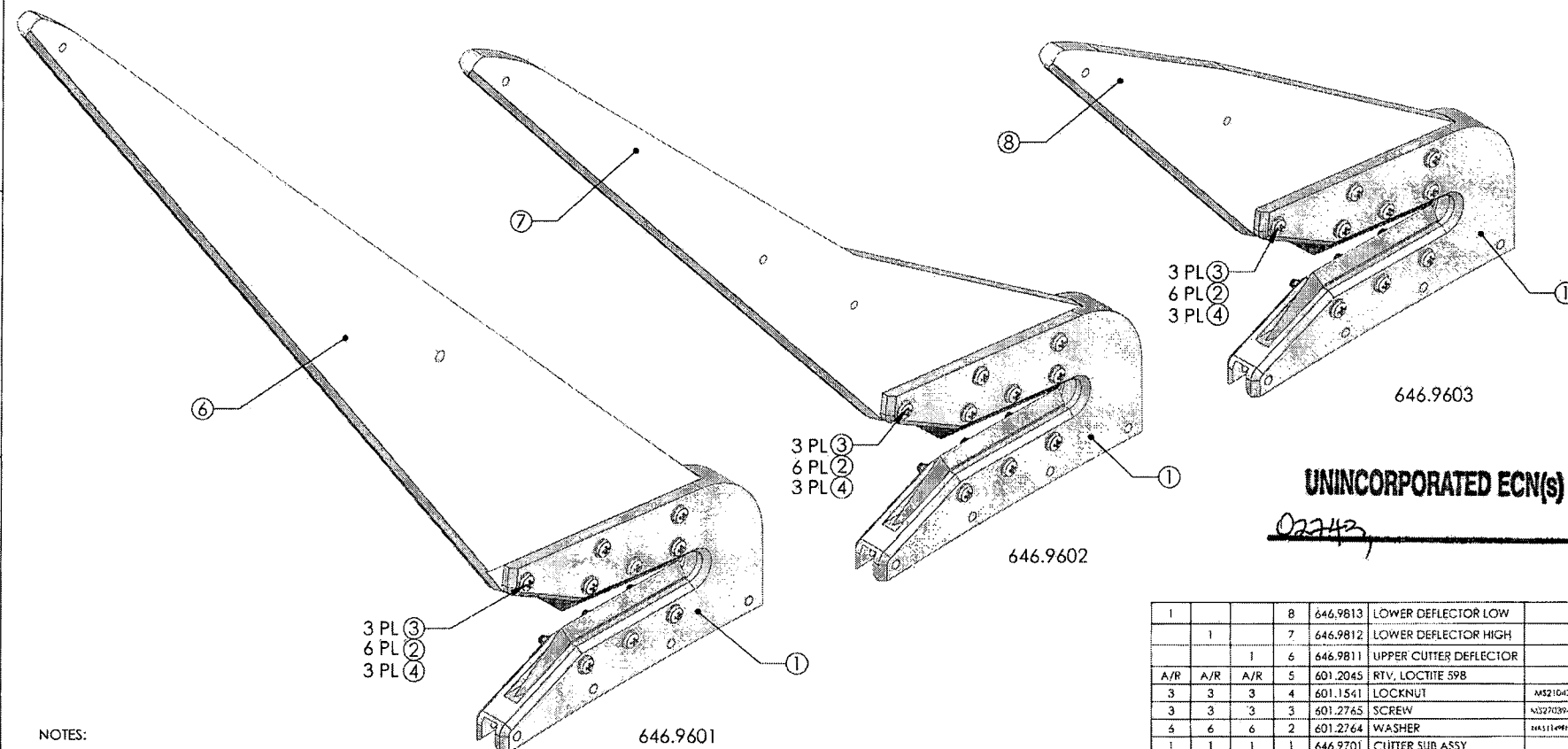
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02743				SHEET 1 OF 1	
	DWG NO. 646.9600		REV IN/C	PREPARED BY S. HUFF	DATE: 01/07/10	EFFECT ON DWG ☐ INC. ☒ UNINC.
	DWG TITLE: CUTTER ASSY					
	APPROVED BY:	ENGR <i>H Bravo</i>	MFG <i>Amel Gorgy</i>	QC <i>Maal Lyan</i>	EFF: NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED SCREW LENGTH.					

138188-MCS
 15-10-27
 138188-MCS
 15-10-27

3	R	601.3157	3	3	3	SCREW	MS27039-0818
			.9603	.9602	.9601		
F/N	TC	PART NUMBER	QTY	DESCRIPTION			MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:				☐ MDL ☐ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM			CHANGE CATEGORY ☐ MAJOR ☒ MINOR
							DER REVIEW REQUIRED ☐ YES ☒ NO

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION PER 1		FUC
2	FINAL RELEASE	04/30/00	P. BRAVO



UNINCORPORATED ECN(S)

02243

NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 6, 7, & 8 UPON ASSEMBLY

1			8	646.9613	LOWER DEFLECTOR LOW		
	1		7	646.9612	LOWER DEFLECTOR HIGH		
		1	6	646.9611	UPPER CUTTER DEFLECTOR		
A/R	A/R	A/R	5	601.2045	RTV, LOCTITE 598		
3	3	3	4	601.1541	LOCKNUT	MS21042L08	
3	3	3	3	601.2765	SCREW	MS27039-0019	
5	6	6	2	601.2764	WASHER	MS11449H502P	
1	1	1	1	646.9701	CUTTER SUB ASSY		
				646.9603	LOWER CUTTER ASSY LOW		
				646.9602	LOWER CUTTER ASSY HIGH		
				646.9601	UPPER CUTTER ASSY		
.9603	.9602	.9601	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY		PARTS LIST	
NEXT ASSY (S)		APICAL INDUSTRIES	
646.9500		2608 TEMPLE HEIGHTS DR.	
		OCEANSIDE, CA. 92056-3512 (760)724-5300	
		CUTTER ASSY	
		SEE CASE CODE B 07M26	
		DWG NO. 646.9600	
		SCALE NONE	
		SHEET 1 OF 1	